

Work Order ID 81126-2

March-08-12 8:55:05 AM

\*81126\*

Page 1

Item ID: D3560-044

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/09 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 15.500" long

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA696 Rev: AA & Dwg D3560 Rev: D  
 2-C"sink 0.196" hole on manual mill as per dwg D3560  
 3-Deburr per dwg D3560

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81126**

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**\*81126\***

Page 2

Item ID: D3560-044

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check 0.00

**\*130\***

QC

Memo

0.00

out 12/04/10

6

Quality Control

140

0.00

**\*140\***

Large Fab

Large Fab

Memo

0.00

4

16  
12.04.27

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad )

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch ( 65 deg C )

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near

end) 11- same for remaining side (ease off pedal near end)

Alum Rod # M120854

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

Scrl 4/30

4  
-044

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*160\***

QC

Memo

0.00

Quality Control

4 8 BE12/04/30

170

Chemical Conversion Coat per QSI005 4.1

0.00

**\*170\***

HandFinish

Memo

0.00

Hand Finishing

4 1612-5-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC3- Inspect Part Finish

0.00

**\*180\***

QC

Memo

0.00

Quality Control

4x  $\phi$ 

8/12/05/01

190

Small Fab

0.00

**\*190\***

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

4x  $\phi$ 

8/12/05/01

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

(4)

8/12/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March-08-12 8:55:05 AM

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Page 5

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Revision ID:

Stop **\*NS2\***

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00 **\*6\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00 **\*6\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

210

Identify as per dwg & Stock Location: *WA*

0.00

**\*210\***

*STEP CELL*

Packaging

Memo

0.00

Packaging

\*\*\* STOCK IN STEP CELL\*\*\*

*(4)*

*Ac  
12.05.01*

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

*12/5/11*

*MF  
12-05-01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

March-08-12 8:55:08 AM

Page 1

Work Order ID: 81126

\*81126\*

Parent Item: D3560-044

\*D3560-044\*

Parent Item Name: Arm Weldment

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC  
IPP Rev B ECN 987 07.10.09 EC verified by DD  
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured

No

100

Each

35.0000

1

6

\*D2808\*

Bushing

\*\*

Location

Loc Qty

Loc Code

GA

35

32896

2

79688

33

M6061T6B0.500X05.00  
0

Purchased

No

140

f

75.2274

1.295

8.178947

\*M6061T6B0 500X05 000\*

6061-T6 Bar .500 x 5.00

\*\*

Location

Loc Qty

Loc Code

MAT001

21.834

112154

6.935

117933

2.123

119346

12.776

MAT004

53.3934

120243

24

120421

5.3934

120866

24

M121040 x 8.18

12/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

March-08-12 8:55:08 AM

Page 2

Work Order ID: 81126

Parent Item: D3560-044

Parent Item Name: Arm Weldment

\*81126\*

\*D3560-044\*

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3592-1

Manufactured No

190

Each

17.0000

1

6

\*D3592-1\*

Plate

\*\*

*12.04.27*

Location

Loc Qty

Loc Code

WA

15

79715

15

WA002

2

47015

2

*4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

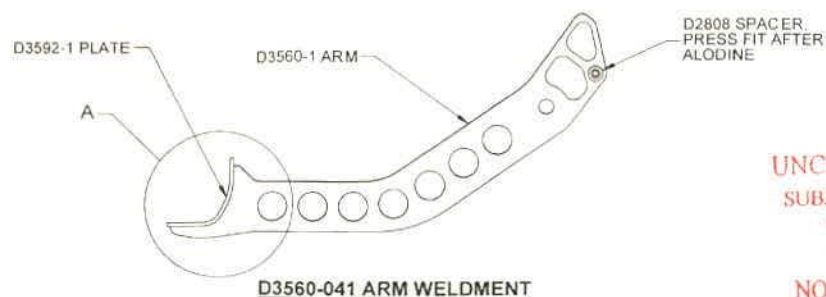




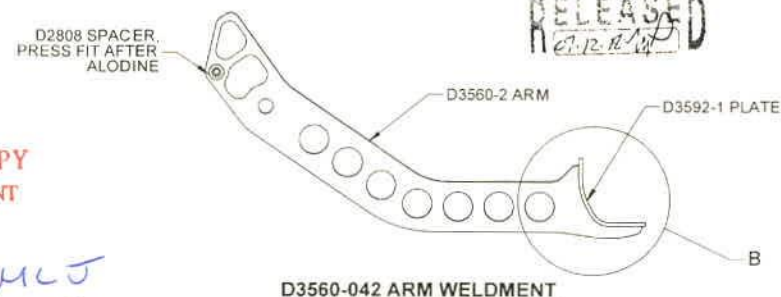
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07.12.16

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

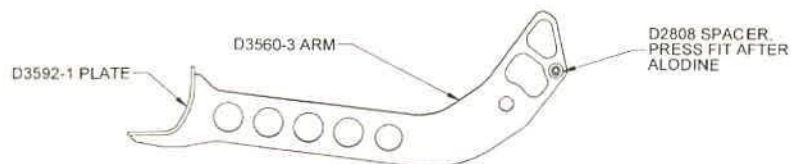
NO. 81126 MCT  
12/03/09



D3560-041 ARM WELDMENT



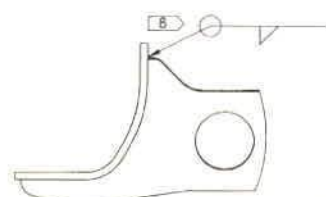
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



DETAIL A  
SCALE 1:2

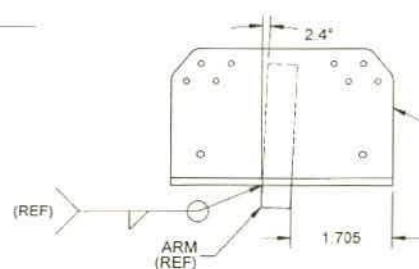
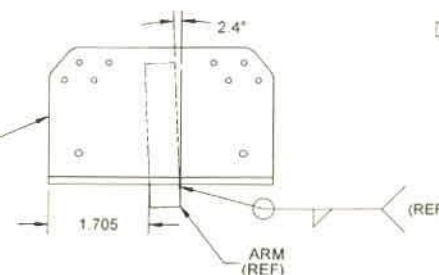


PLATE  
(REF)



DETAIL B  
SCALE 1:2

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D3560  
TITLE  
ARM WELDMENT  
REV. D  
SHEET 1 OF 5  
SCALE  
1:4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

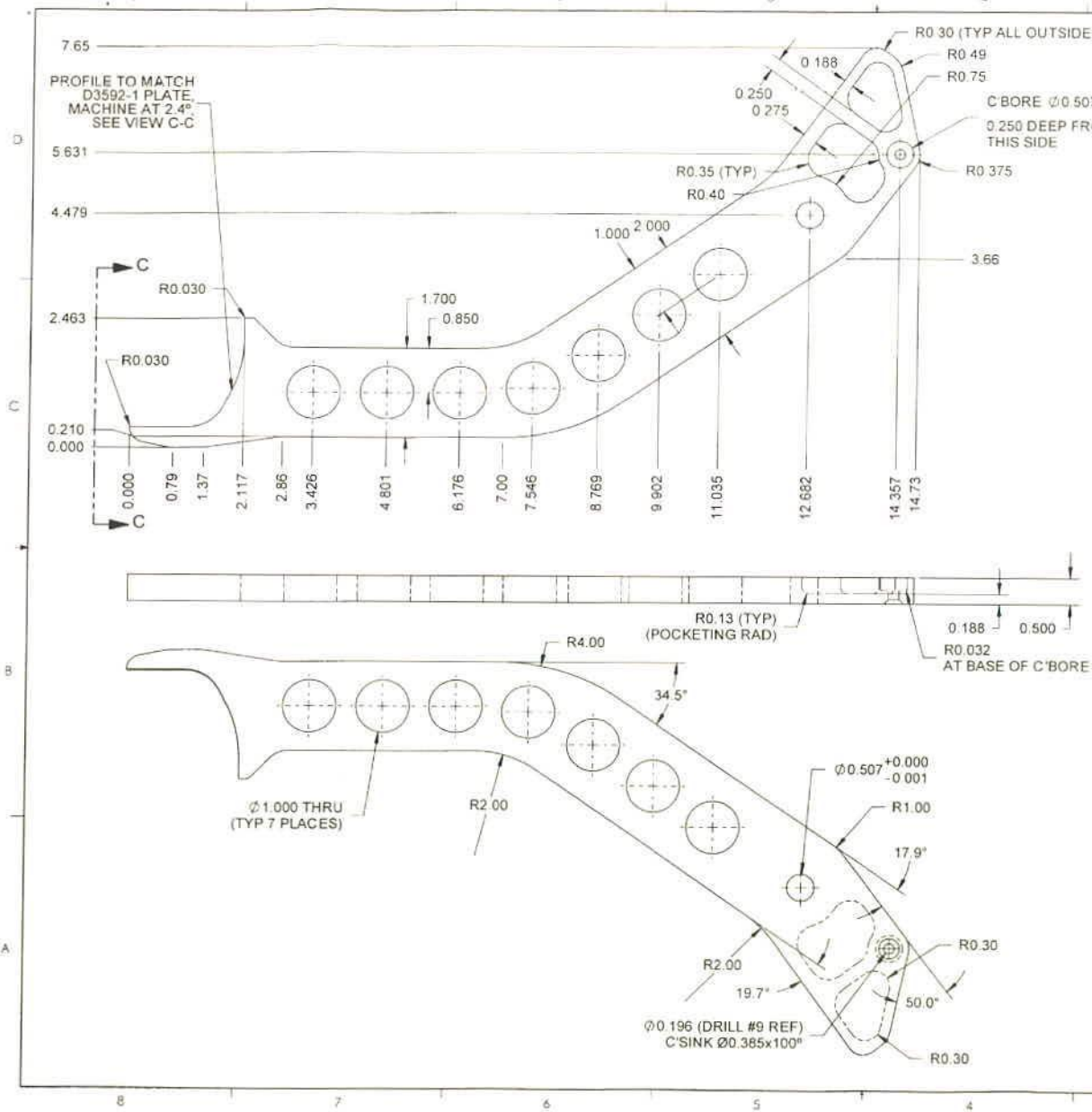
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81126



# **D3560-1 ARM WELDMENT**

## **NOTES**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/B (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/B (OR AMS 4160)  
(REF: DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



RELEASED  
07.12.16

DESIGN	07	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JK			
CHECKED	JK		DRAWING NO	REV. 1
MFG APPR.	JK		D3560	SHEET 2 OF 5
APPROVED	JK		TITLE	SCALE
DE APPR.	JK		ARM WELDMENT	1:1
DATE	07.11.16		COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR ANY OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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07-12-12

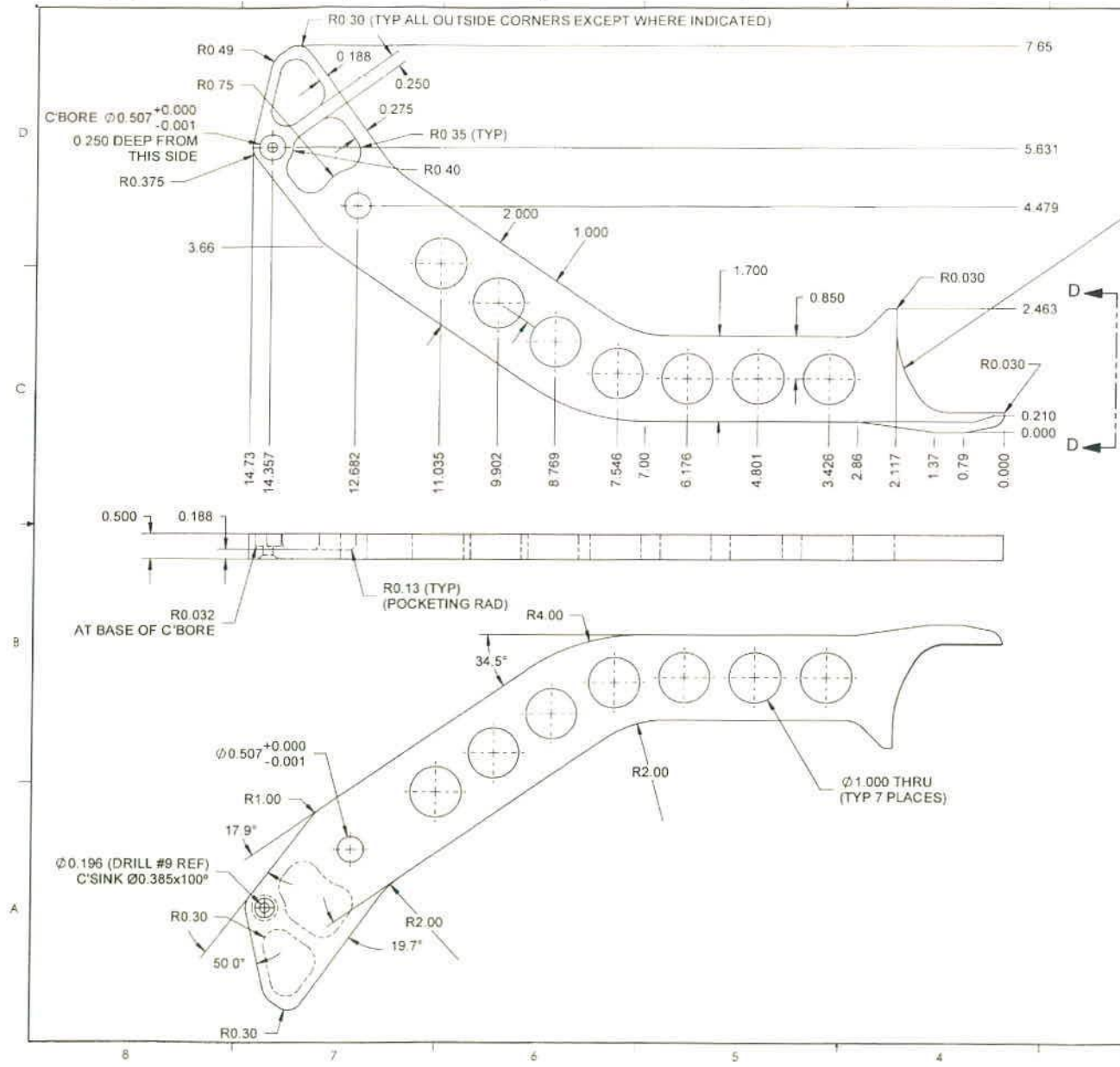
PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4°  
SEE VIEW D-D

# D3560-2 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 41128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC M6061T6B0 500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs.



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. D
MFG. APPR.		D3560	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD</small>	





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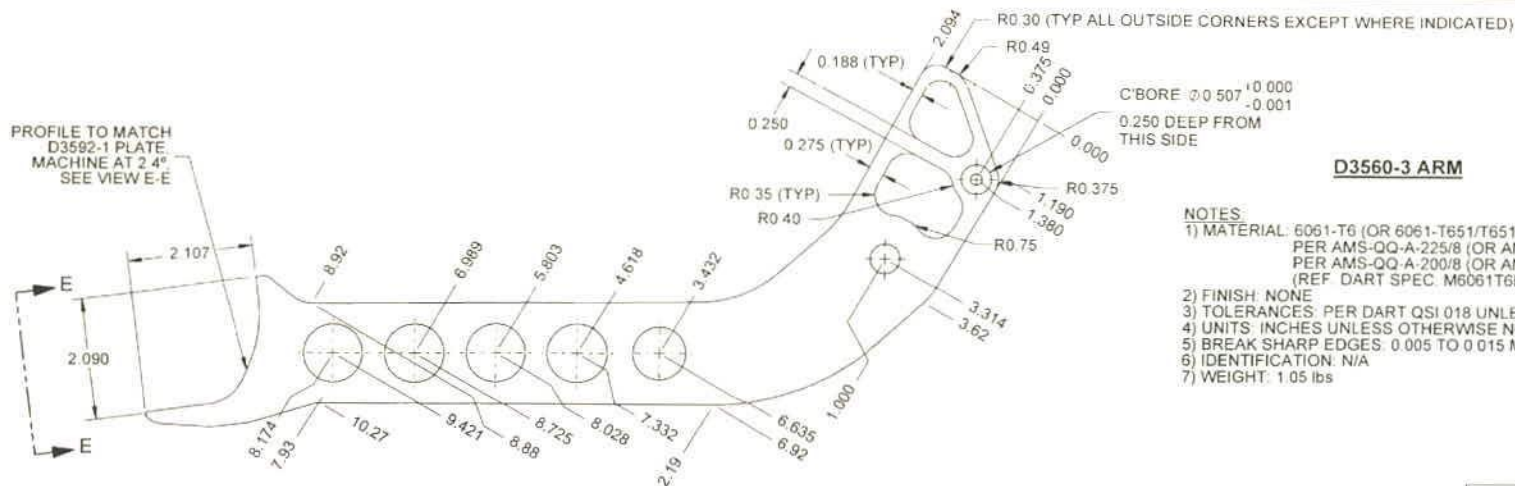
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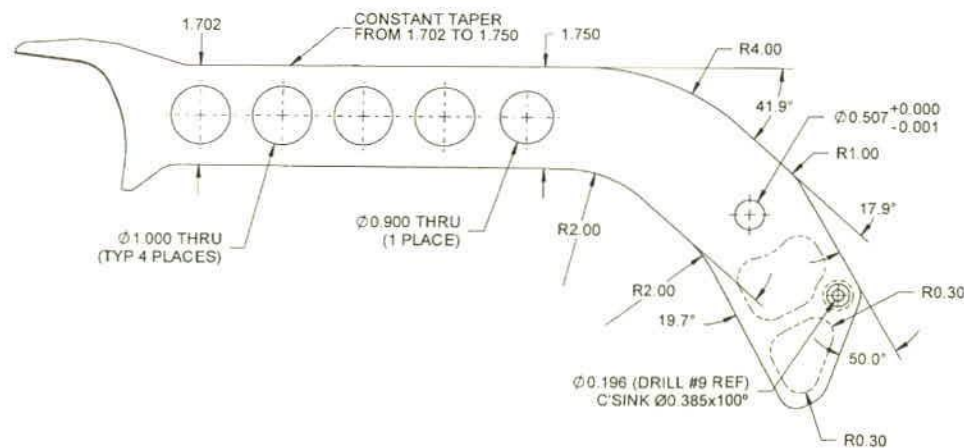
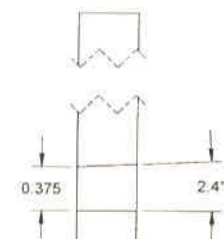
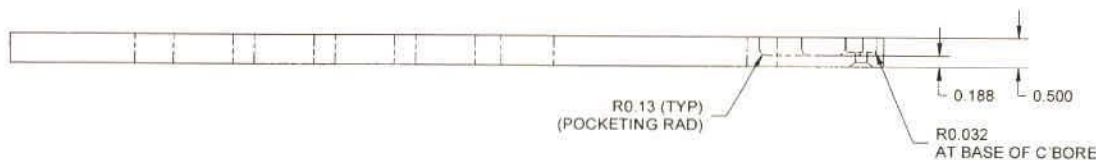
81126

PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4"  
SEE VIEW E-E



### D3560-3 ARM

- NOTES
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs



DESIGN	4C	DART AEROSPACE LTD	
DRAWN	4C	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4C	DRAWING NO.	REV. D
MFG. APPR.	4C	D3560	SHEET 4 OF 5
APPROVED	4C	TITLE	SCALE
DE APPR.	4C	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

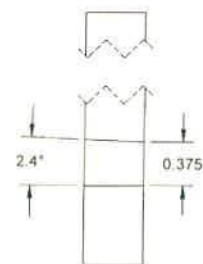
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

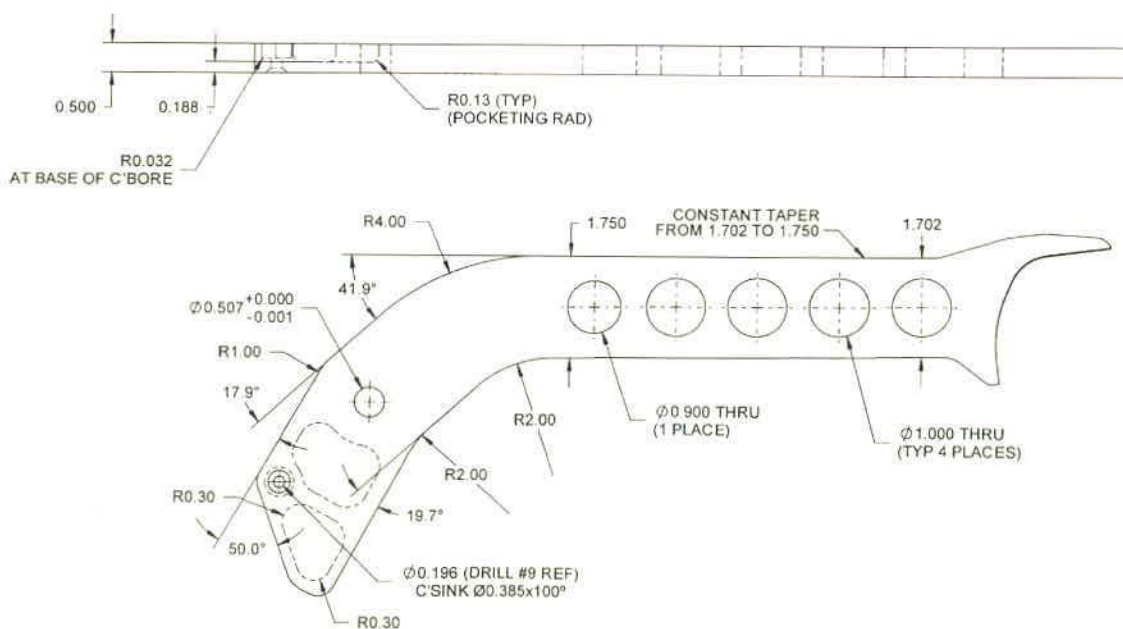
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PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. PART SPEC. M6061T6B0.500)
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW F-F  
SCALE 1 : 1

FILED  
11 07-12-18 MP



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED TO THE BUSINESS CUSTOMER UNDER THE CONDITION THAT IT IS NOT TO BE USED FOR ANY REPRODUCTION OR COPIED, OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries